

# SECTION 1

## Operating Instructions

### 1.1.1 TECHNICAL SPECIFICATION

#### 1205

**Form sizes**      Width 5" to 17 1/2" (127mm to 445mm)  
                          Depth 2" to 99 5/6" / 99 7/8" (51mm to 2536mm / 2537mm)  
                          Strip Cut    1/6"/1/8" to 3 5/6"/3 7/8" (4.2mm/3.2mm to 97mm/98mm)

**Form weights**    All standard commercially available stock  
                          from flimsy papers to heavy card and up to  
                          6 part sets, including carbon interleaved and  
                          self copying papers.

**Weight Range:** Min. - 55 gsm (15 lbs bond)  
                          Max. - 400 gsm (106 lbs bond)

#### **Fixed Operating Speeds (forms per hour)**

Without strip cut	With strip cut
4" deep forms 9,000	4" deep forms 6,000
6" deep forms 8,000	6" deep forms 5,000
8" deep forms 6,500	8" deep forms 4,500
12" deep forms 5,000	12" deep forms 4,000

**Programmable memory**      Capacity for 20 programs

#### 1206

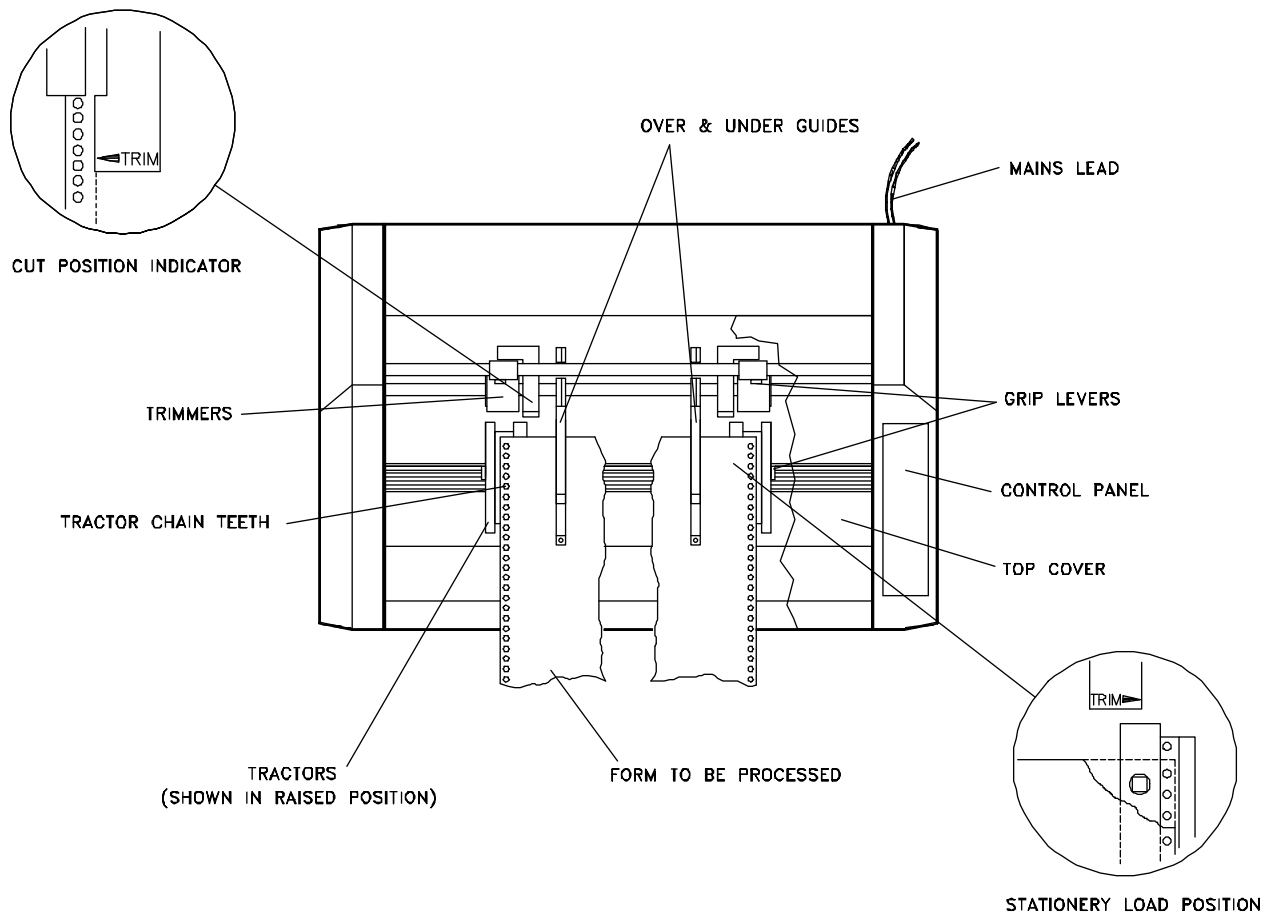
As 1205 above except:

#### **Variable Operating Speeds - up to (forms per hour)**

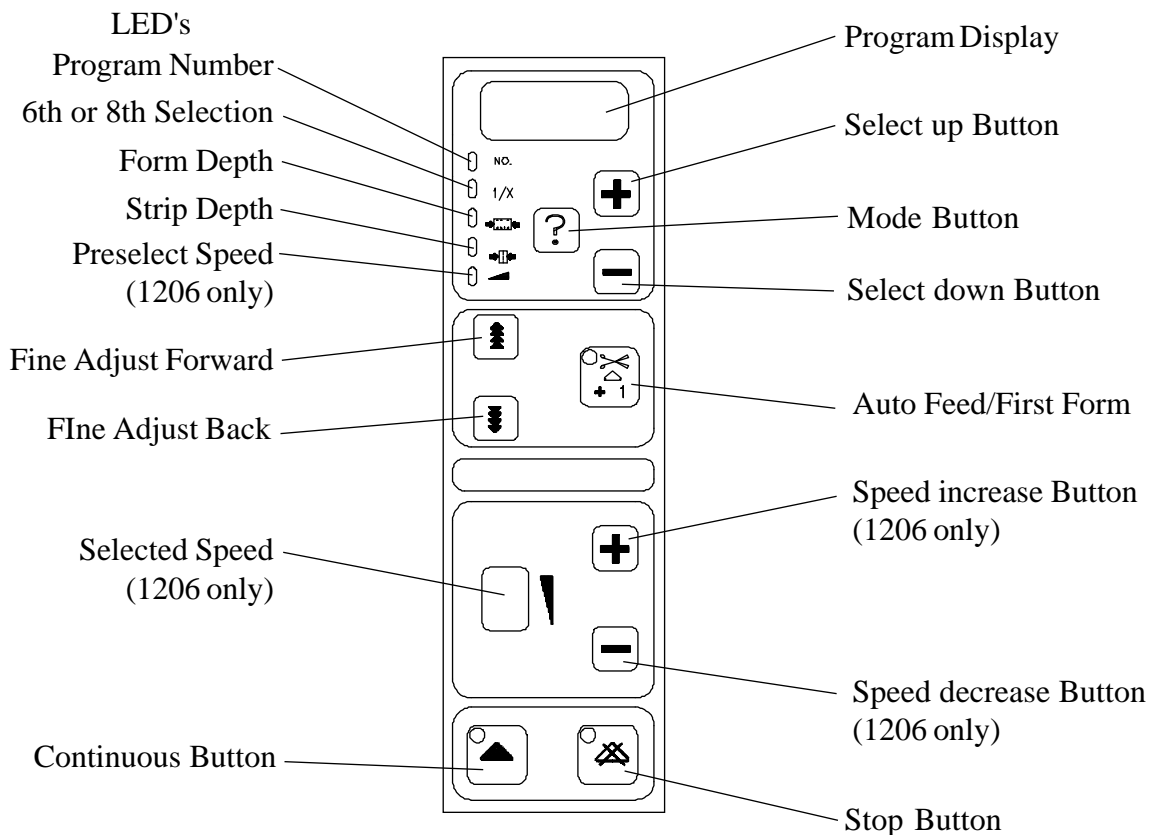
Without strip cut	With strip cut
4" deep forms 12,500	4" deep forms 8,000
6" deep forms 10,800	6" deep forms 7,300
8" deep forms 9,800	8" deep forms 6,900
12" deep forms 8,000	12" deep forms 6,000

**Programmable memory**      Capacity for 30 programs

## 1.1.2 MACHINE LAYOUT DIAGRAM



## 1.1.3 CONTROL PANEL LAYOUT



**NOTE:** THIS MANUAL COVERS THE OPERATION OF BOTH 1205 (FIXED SPEED) AND 1206 (VARIABLE SPEED) CUTTERS. WHERE APPLICABLE, THE DIFFERENCES ARE INDICATED THROUGHOUT.

### 1.2.1 MACHINE OPERATION

1. Plug in machine (at plug point by power switch) and lift top cover.

2. Load stationery on tractors

To set tractor position, release tractor grip levers and slide tractors inwards or outwards to accommodate stationery onto pins. Ensure that stationery is neither too tightly stretched, nor too loose between tractors. Position stationery so that the leading edge is just covering the sensor in the RH tractor unit (see inset view on Machine Layout Diagram). When satisfied, lower tractor tops and lock grip levers.

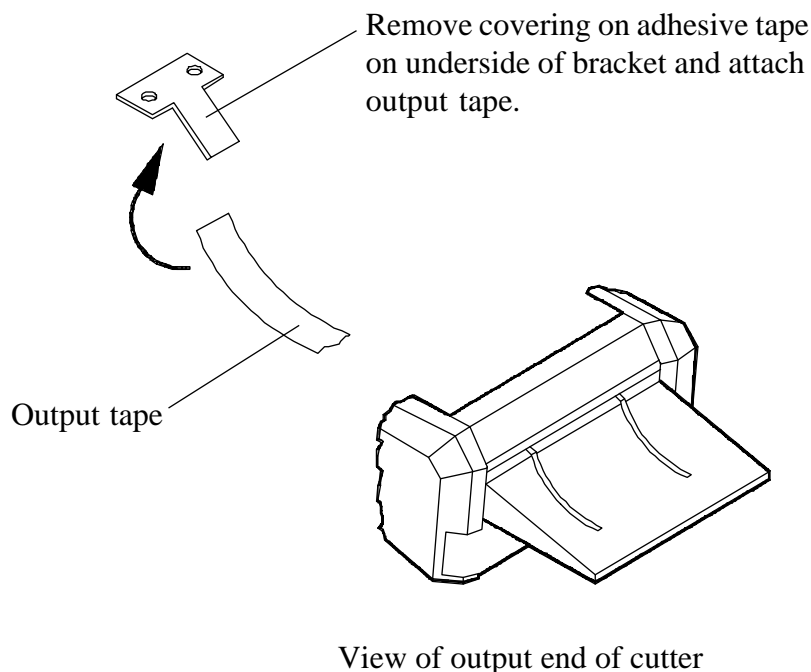
3. Set trimmer position

To set trimmer position, release trimmer grip levers and slide trimmers across until cut position indicator aligns with the horizontal position on the form where the desired cut is to be made (see inset view on Machine Layout Diagram). This position is normally slightly inboard of the form perforations.

To assist alignment, it may be helpful to manually wind the form forward by turning the splined tractor shaft. This will move the leading edge closer to the cut position indicator. If this is done, ensure that the form is moved back to its original position of just covering the sensor.

Note: power must be OFF in order to manually turn shaft.

4. Attach output tapes as shown below:



5. Lower top cover and switch on machine. No motors will run at this stage, and the machine will display a start-up greeting "HI" on the display panel. This will last for about 3 seconds, and then change to indicate the last used program number ("Pn").
  6. Select desired program by pressing 'select up' (+) or 'select down' (-) buttons. See section 1.2.2 for further details on Program Selection.
  7. Press Auto feed/First form button to feed and cut the first form.
  8. Set magnetic paper stops on output tray to accommodate the cut form size.
  9. Feed a single form onto the output tray. This is done by pressing and holding the 'Stop' button and then simultaneously pressing the 'Continuous' button once. Check that the paper stops are in the right place on the output tray, and that the cuts are in the correct position.
  10. If the horizontal cut is occurring in the wrong position, this can be adjusted forwards or backwards by pressing the 'Fine adjust' buttons. The amount of displacement will be shown on the display panel in units of 1/96". Default is "00", one increment forward will show "01" and one increment back will show "-01". The fine adjustment applies equally to single or strip cut.
  11. Press 'Continuous' button, and stationery will run through the machine, delivering the cut forms onto the output tray.  
**1206 only:** speed may be varied at this stage by pressing the 'Speed increase/decrease' buttons.
- When required, press 'Stop' button to halt continuous run.
12. When the last form of the run enters the machine, it will be processed onto the output tray and the machine will recognise that there are no more forms to follow. No further cuts will be made.
  13. Switch off machine and unplug mains supply when work is complete.

**Note:**

If the machine is switched on and remains idle for more than one minute, the main drive motor will automatically be powered down.

# 1205/1206 CUTTER

## 1.2.2 OPERATOR PROGRAM INSTRUCTIONS

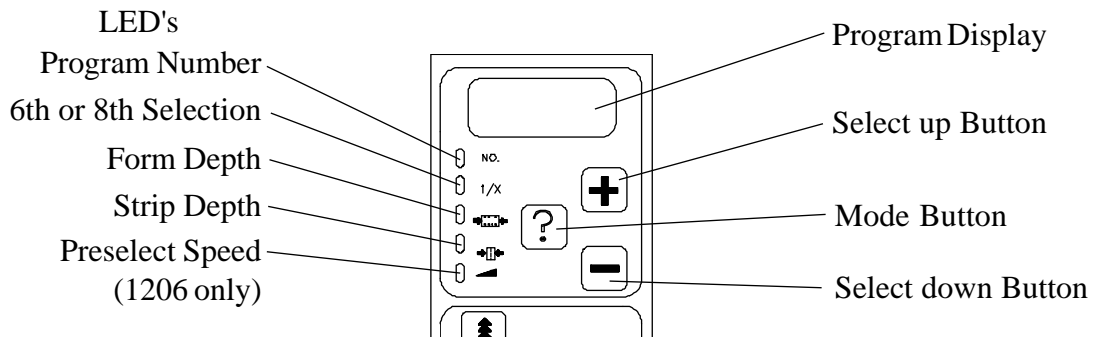
The machine may be programmed with up to 30 programs (1206) or 20 programs (1205). The first 10 are factory set, and the settings for each are shown below.

PROGRAM No.	FORM DEPTH	STRIP CUT
1	4"	NO
2	8"	NO
3	11"	NO
4	11 4/6"	NO
5	12"	NO
6	4"	YES
7	8"	YES
8	11"	YES
9	11 4/6"	YES
10	12"	YES

The desired program is selected after switching on the machine and after the "HI" startup message has been replaced by the number of the last used program. Press program 'Select up/down' buttons to the required number. You may define your own program settings for numbers 11 - 30 (1206) or 11 - 20 (1205), as described below and overleaf. Programs 1 - 10 can also be changed and overwritten if desired.

## 1.2.3 USER DEFINED PROGRAM SETTING

To define settings for programs 1-30 (1206) or 1-20 (1205), initially set the Program number to that desired by pressing the 'Select up' button after start-up. The number will flash if not currently programmed. Refer to control panel detail below for the controls used throughout this section.



## 1205/1206 CUTTER

Press 'Select up' (+) and 'Select down' (-) buttons together and hold down for 5 seconds. The Program number LED will begin flashing, and the selected program number on the Display panel which was previously flashing (if not previously programmed) will become static.

Press the 'Mode' button and the 6th or 8th selection LED will begin flashing. Press 'Select up' (+) or 'Select down' (-) button to set 6th's or 8th's, as indicated on the Display panel. This refers to units in either 6th's or 8th's of an inch.

Press the 'Mode' button again and the Form depth LED will begin flashing. Press 'Select up' (+) or 'Select down' (-) button to set the desired form depth. The Display panel will indicate whole inches followed by the selected units, either 6th's or 8th's, eg. 8.5 would indicate 8 5/6" if 6th's were selected.

Press the 'Mode' button again and the Strip depth LED will begin flashing. Press 'Select up' (+) or 'Select down' (-) button to set the desired strip depth, ie. the total depth of the strip that will encompass the perforation. The Display panel will indicate the strip depth in the selected units, eg. 0.1 would indicate 1/6" if 6th's were selected. The initial value is 0.

**1206 only:** Press the 'Mode' button again and the Preselect speed LED will begin flashing. Press 'Select up' (+) or 'Select down' (-) button to set the desired speed, which will be indicated in the Display panel. Note that this setting can be overridden at any time during operation by pressing the 'Speed increase/decrease' buttons.

Press the 'Mode' button again and the selected program number will be shown on the Display panel. The program is now entered into memory and will remain at these settings unless it is overwritten. The memory otherwise remains intact even after the mains supply is disconnected.

Programs 1-30 (1206) or 1-20 (1205) can be re-programmed at any time. Note that if 1-10 are re-programmed and it is later desired to reset to default programs, these can all be simultaneously reset by the use of Engineer Test Mode 4. See [section 2.4](#) of this manual for further details.

The settings of all programs (1-20/30) can be confirmed by stepping through with the 'Mode' button with the program number indicating on the Display panel. The display will show:

- 1) Whether 6th's or 8th's selected
- 3) Form depth
- 3) Strip cut depth (if selected)
- 4) Preselected speed (1206 only)



### PROGRAM SETTING FOR TRIM ONLY

It is possible to set the machine for trimming only, with the cutter blade de-activated. To do so, select an unused or redundant program number and program as below:

1. Set for either 6ths or 8ths
2. For form depth, press and hold 'Select up' (+) button until display reaches 99.5 (or 7). The next position gives a display of '--.-' and is the required setting.
3. Set strip cut depth to 0
4. Set desired speed (1206 only). A low initial speed setting is recommended.

The program is now set for trim only, and the cutter blade will not operate.